

NCR-19-7486



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4149-3

Job Sheet 197072



Part No: D4149-3

Job Qty: 30 pcs

Part Name: Spacer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/28/19

Job Tracking No:

Due Date: 7/30/19

Created By: Kimberley Guerin

Type: Stock

Description:

Note: DWG REV C IPP REV:A NEW ISSUE 10-06-24 JLM VERIFIED BY:DD IPP Rev:B 11.03.03 as per revC DD
verf.JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	30 pcs	7/30/19	7/30/19	0.00	0.10	Bandsaw - 1		am L 19/07/18
110	HAAS 4 Axis - B4B	30 pcs	7/30/19	7/30/19	0.12	13.10	HAAS - 1 - B4B		am L 19/07/18
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 8	30 pcs	7/30/19	7/30/19	0.00	0.00	QC 8 - 12		19-07-18
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		



Container No: S198871



Part: D4149-3

Job No: 197072

Serial No/Batch: S198871

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/18/19

Plex 6/28/19 8:06 AM Dart.Guerin.Kimberley

170 Packaging 3-1 - Stock - B4B 30 pcs

7/30/19

0.00 0.00

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

Packaging 3 - 26 - B4B

Packaging 3 - 27 - B4B

Packaging 3 - 28 - B4B

Packaging 3 - 29 - B4B

Packaging 3 - 30 - B4B

Packaging 3 - 31 - B4B

Packaging 3 - 32 - B4B

Packaging 3 - 33 - B4B

Packaging 3 - 34 - B4B

Packaging 3 - 35 - B4B

Packaging 3 - 36 - B4B

180 QC 21 - SA

30 pcs

7/30/19

0.00 0.00

QC 21 - SA - 21

QC 21 - SA - 70

QC 21 - SA - 53

Part Op 100 - (Bandsaw)

Descriptions: 110 - (HAAS CNC Vertical Machine)

130 - (QC8- Inspect parts - second check)

170 - (Identify as per dwg & Stock Location: _____)

180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303B1.000X1.000	M303B1.000 X 1.000	10 ft (.33333333 ea)	100-Bandsaw - 1	5193982 = 10.1

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M303B1.000X1.000	10	27	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	0.129Inches + 0.005 - 0.001	0.134 0.128	Diameter	
2	Spacer	0.380Inches ± 0.030	0.410 0.350	Diameter	
3	Spacer	0.630Inches ± 0.030	0.660 0.600		
4	Spacer	1.588Inches ± 0.010	1.598 1.578		
5	Spacer	2.430Inches ± 0.030	2.460 2.400		
6	Spacer	0.630Inches ± 0.030	0.660 0.600		
7	Spacer	1.587Inches ± 0.010	1.597 1.577		
8	Spacer	0.750Inches ± 0.030	0.780 0.720		
9	Spacer	0.313Inches ± 0.010	0.323 0.303		
10	Spacer	0.380Inches ± 0.030	0.410 0.350	Radius	
11	Spacer	0.375Inches ± 0.010	0.385 0.365		
12	Spacer	0.750Inches ± 0.010	0.760 0.740		
13	Spacer	0.735Inches + 0.000 - 0.010	0.735 0.725		

Plex 6/28/19 8:06 AM Dart.Guerin.Kimberley

DQA:

Date:

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Date:

Work Order update only ☐

Work Order: <u>197072</u> Part No. <u>D4149-3</u> NCR No. <u>19-7486</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																			
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Date : <u>19-07-18</u>		Step #: <u>110</u>		QTY Effective : <u>X 29</u>		MRB (QS1042) Approval DAS 55 9-89 <u>19/7/19</u>																																																																			
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